

**Work Order ID 117736**

Thursday, May 01, 2014 10:20:24 AM

**\*117736\***

Page 1

Item ID: D3140-08

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Door

Start Date: 5/1/2014 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 8/22/2014 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan: CLDate: 14/05/01

Tooling:

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3140

Rev F

100

0.00

**\*100\***

Packaging

Memo

0.00

Packaging

Pick kit to ship to Delastek

CL 14/05/05

110

QC4- 100% Inspect kits for completeness

0.00

**\*110\***

QC

Memo

0.00

Quality Control

SEP 16 2014DAS  
06  
9-89

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%; font-size: small;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
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Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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**Work Order ID 117736**

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**\*117736\***

Page 2

Item ID: D3140-08

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Door

Start Date: 5/1/2014 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 8/22/2014 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

0.00

**\*120\***

Purchasing

Memo

0.00

Purchasing

Issue P/O: 24037

Purchase Part Number: D3140-08

Supplier: Delastek

\*\*\*Ship kit and make as per dwg\*\*\*

Conformity Certificate and Process sheet required

CZ 14/05/05 ①

130

Receive &amp; Inspect for Damage &amp; Mat'l Certs

0.00

**\*130\***

Packaging

Memo

0.00

Packaging

14/9/16 ①

140

QC6- Inspect dimensions to drawing

0.00

**\*140\***

QC

Memo

0.00

Quality Control

Ensure a copy of certification of conformity and process sheet from Delastek is attached.

1 14/9/17

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Handling/Pre									
Material									
Operator									
Offset/Setup									
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Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

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**\*117736\***

Page 3

Item ID: D3140-08

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Door

Start Date: 5/1/2014 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 8/22/2014 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

**\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>CA</u>	0.00							
<b>*150*</b>									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									

RT 14-09-1714/9/1714-9-17

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

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Design <input type="checkbox"/>									
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Handling/Pre <input type="checkbox"/>									
Material <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Offset/Setup <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Transport <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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# Picklist Print

Thursday, May 01, 2014 10:20:23 AM

Page 1

Work Order ID: 117736

**\*117736\***

Parent Item: D3140-08

**\*D3140-08\***

Parent Item Name: Door

Start Date: 5/1/2014

Required Date: 8/22/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.01.17 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3140-10		Manufactured	No			100	Each	4.0000	1	1			
<b>*D3140-10*</b>									<b>**</b>				
Doubler Assembly													

Location Loc Qty Loc Code

ST156 4  
53768 4

D3140-92		Manufactured	No			100	Each	10.0000	1	1			
<b>*D3140-92*</b>									<b>**</b>				
Doubler													

Location Loc Qty Loc Code

CA 10  
34374 1  
50384 9

D3140-99		Manufactured	No			100	Each	3.0000	1	1			
<b>*D3140-99*</b>									<b>**</b>				
Doubler													

Location Loc Qty Loc Code

CA 3  
36761 1  
52632 2

D3140-101		Manufactured	No			100	Each	3.0000	2	2			
<b>*D3140-101*</b>									<b>**</b>				
Doubler													

Location Loc Qty Loc Code

ST027 3  
78724 3

05/14/05/05

05/14/05/05

05/14/05/05

05/14/05/05

miss ①

B118968 x1

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

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Material									
Operator									
Offset/Setup									
Process									
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# Picklist Print

Page 2

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Work Order ID: 117736

**\*117736\***

Parent Item: D3140-08

**\*D3140-08\***

Parent Item Name: Door

Start Date: 5/1/2014

Required Date: 8/22/2014

Start Qty: 1.00

Required Qty: 1.00

D3140-104

Manufactured No

100

Each

2.0000

1

1

**\*D3140-104\***

Doubler

\*\*

C214/05/05

Location

Loc Qty

Loc Code

CA

2

34378

2

D3140-106

Manufactured No

100

Each

2.0000

1

1

**\*D3140-106\***

Doubler

\*\*

C214/05/05

Location

Loc Qty

Loc Code

CA

2

34380

2

D3140-303

Manufactured No

100

Each

2.0000

1

1

**\*D3140-303\***

Doubler

\*\*

C214/05/05

Location

Loc Qty

Loc Code

ST241A

2

84215

2

D3140-08 P

X 1

117736 12/7/14 C

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other  _____ _____ _____
--	--	---	---



DELASTEK Inc.  
2699 5e Avenue  
Local 14,  
Grand-Mère, Québec G9T 2P7  
Canada  
Tel.: (819) 533-5788  
Fax: (819) 533-3494

# PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice No.	58219
Customer No.	DART US

## Bill To

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

Telephone : 613-632-5200  
Contact : Linda Lacelle

## Ship To

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

Telephone : 613-632-5200  
Contact : Linda Lacelle

Ship Date	Order Date	Our SO #	Ordered by	Your PO#	Terms
09-09-2014	01-05-2014	24599	Michael Gregoire	PO24037	Net 30 days USA
Ship Via	F.O.B.	Salesperson	GST/PST		
Fedex Freight LTL Collect	Point de départ	Melody Shapcott, ext. 235			
Order Qty	B.O. Qty	Current Ship	Item number	Description	
1	0	1	DKC135-0019	Line #2 D3140-06 Door Right Non Assy (Grosse) U of M: Chaque DWG D3140 REV. F Serial # Lot # 61668. 61668	
1	0	1	DKC135-0020	Line #4 D3140-08 Door Right Non Assy ( Petite ) U of M: Chaque DWG D3140 REV. F Serial # Lot # 61668. 61668	

DOCUMENT INCLUS



*It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request*

Accepted by:

Quality department

AQ-357

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Date: Jeudi, 2014-05-08 14:25:00  
Utilisateur: marc dubé

## Feuille de Procédé

8/9 juin

Client	: DART US DART AEROSPACE	Nom Dessin	: DOOR KIT		
Numéro Job	: 61668	Numéro Article	: DKC135-0019/0020		
Numéro	: 3407	Numéro Dessin	: D3140		
Numéro B.A.	:	Projet Numéro	: DK-359		
Cette fois	: 2014-05-08 No. :	Révision dessin	: F		
Prsht Rev.	: NC	Matériel	: Fibercote E-761		
Prem. fois	: - - Type :	Date Dûe	: 2014-05-15	Qté:	1 Ud UNITE
Job précédente	: 40734		<del>2014-05-15</del>		

Écrit par : \_\_\_\_\_  
Vérifié & Approuvé par : \_\_\_\_\_  
Commentaires : N° de pièce Client: D3140-06/08

Process Sheet Rév.: 05 remplacer AAC0559 et AAC0563 par AAC2032 et AAC1361 respectivement, changé AC0883 et AC0884 par AAC1885 et AAC1887 respectivement à 2 endroits qui avait été oubliés

COPIE

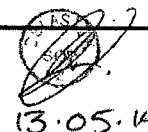
## Produit additionnel

Numéro Job:



# Séq.: Machine ou Description :

1.0 AAC0854 AAC2384 Frekote #700-NC # 710 NC  
Comment Qty 0.030 UNITE(s)/Unit Total 0.030 UNITE(s)  
Frekote #700-NC N° de Lot: 1-44859-1



13.05.14

2.0 PRÉPARATION Préparation du moule



Comment Setup: 0.00Hrs/ Run: 130.0000Min Total Run: 2.1667Hrs

Faire la préparation du moule selon JF135-0002 et IG 0009.

Date: 14/05/14 Sceau:



3.0 AMB0211 Epoxy prepreg E-761 style 7781

Comment Qty.: 12.30 VERGE(s)/Unit Total: 12.30 VERGE(s) 21.5 verges  
Epoxy prepreg E-761 style 7781 N° de Lot: 4535710AA

25 18 juin 2014



4.0 DECOUPE Découpe manuelle des pièces



Comment Setup: 0.00Hrs/ Run: 60.0000Min Total Run: 1.0000Hrs

Découpe des tissus pré-impregné E-761 en paquet de 40.5 pi (7 Paquet = 24.5 verges)

à la Gerber AMB0211 DKC135-0017/0018

Quantité: 1 Date: 26-06-14 Sceau:



draper avec le # du pli par en dessous
















4450 N.S.

25 18 juin 2014



Date: Jeudi, 2014-05-08 14:25:01  
Utilisateur: marc dubé

## Feuille de Procédé

Client:	DART US DART AEROSPACE	Nom Dessin:	DOOR KIT
Numéro Job:	61668	Numéro	DKC135-0019/-0020
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
5.0	DRAPAGE	Drapage	
		 	
Comment	Setup: 0.00Hrs/ Run: 12.0000Hrs Total Run : 12.0000Hrs		
	Faire le drapage de 3 plis de tissus E-761 (4 Paquets) selon IF135-0002 + plan de découpe tissus		
Quantité:	1	Date:	7/07/14
		Sceau:	 
6.0	AAC1885	Tissu à délaminer Release ply B	
Comment	Qty.: 4.37 VERGE(s)/Unit Total : 4.37 VERGE(s) Tissu à délaminer Release ply B # de Lot: N/A		
7.0	AAC1887	Wrightlon 5200 Bleu P3	
Comment	Qty.: 7.18 VERGE(s)/Unit Total : 7.18 VERGE(s) Wrightlon 5200 Bleu P3 # de Lot: N/A		
8.0	AC0885	Feutre de drainage N° Airweave N 10	
Comment	Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s)		
9.0	AC0882	Sac à vide N° Strechlon 700	
Comment	Qty.: 7.770 VERGE(s)/Unit Total : 7.770 VERGE(s)		
10.0	AC0886	Ruban à gommer jaune #. TAT 200Y	
Comment	Qty.: 2.0000 ROULEAU(s)/Unit Total : 2.0000 ROULEAU(s)		
11.0	BAGGING	Faire le bagging sur la pièce	
			
Comment	Setup: 0.00Hrs/ Run: 180.0000Min Total Run : 3.0000Hrs		
	Faire le bagging sur la pièce selon IF135-0002 et IG 0012.		
Quantité:	1	Date:	7/07/14
		Sceau:	 
12.0	CUISSON	Cuisson de pièce	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs		
	Faire la cuisson de la pièce selon IF135-0002, IG 0012 et PTN #20. N°		
Cuisson:	8625		
Quantité:	1	Date:	7-07-14
		Sceau:	
13.0	DÉMOULAGE	Démoulage de la pièce	
			
Comment	Setup: 0.00Hrs/ Run: 240.0000Min Total Run : 4.0000Hrs		
	Retirer le montage cuisson et faire les retouches de la pièce afin d'enlever les surplus de résine et les résidus de tissus à délaminer.		

Date: Jeudi, 2014-05-08 14:25:01

Utilisateur: marc dubé

## Feuille de Procédé

Client: DART US DART AEROSPACE

Nom Dessin: DOOR KIT

Numéro Job: 61668

Numéro DKC135-0019/-0020

Numéro Job:



# Séq.:

Machine ou Opération:

Description:

Quantité: 1

Date: 7/08/14

Sceau:



14.0

INSPECTION

Inspection générale



Comment Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Inspection de la première coquille par le département de la qualité pour s'assurer qu'il n'y aie pas de réparation à faire avant la prochaine étape.

Quantité: 1

Date: 7/08/14

Sceau:



15.0

AAC1618

Rohacell 71S 1"thick 49.2" x 98.4" plain

Comment

Qty.: 2.000 FEUILLE(s)/Unit Total : 2.000 FEUILLE(s)

Rohacell 71S 1"thick 49.2" x 98.4" plain

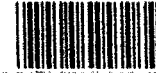
N° de Lot:

1-45755-1

16.0

DECOUPE

Découpe manuelle des pièces



Comment Setup: 0.00Hrs/ Run: 900.0000Min Total Run : 15.0000Hrs

Faire la découpe des pièces de mousses structurales (Rohacell) sur la scie à ruban selon IF135-0002.

Quantité: 1

Date: 18/06/14

Sceau:



17.0

SÉCHAGE/ ANEAL

Séchage / Anealing



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire le séchage du Rohacell selon IF135-0002 et les informations du manufacturier. N°

Cuisson: 8568

Quantité: 1

Date: 13/06/14

Sceau:



18.0

AMB0442

Film adhesif EA9696 36" large x 0.06(psf)

Comment

Qty.: 6.12 VERGE CAR(s)/Unit Total : 6.12 VERGE CAR(s)

Film adhesif de EA9696 36" large x 0.06 (psf)

N° de Lot:

5-75 verges 2 18 juin 2014

19.0

AAC2032

Core splice adhesive NB-51/301

Comment

Qty.: 5.0 PIED CARRE(s)/Unit Total : 5.0 PIED CARRE(s)

Core splice adhesive NB-51/301

# de Lot:

4617910 AA

20.0

AAC1361

Putty AD Tech P-17

Comment

Qty.: 0.50 UNITE(s)/Unit Total : 0.50 UNITE(s)





Putty AD Tech P-17

# de Lot:

1-45756-1

















Date: Jeudi, 2014-05-08 14:25:01  
Utilisateur: marc-dubé

## Feuille de Procédé

Client: DART US DART AEROSPACE		Nom Dessin: DOOR KIT	
Numéro Job: 61668		Numéro DKC135-0019/-0020	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
21.0	AAC1646	N° D3140-10, Doubler	
Comment	Qty.: 1 UNITE(s)/Unit N° D3140-10, Doubler	Total : 1 UNITE(s) N° de Lot: 1-45913-13	
22.0	AAC1631	N° D3140-87, Doubler	
Comment	Qty.: 1 UNITE(s)/Unit N° D3140-87, Doubler	Total : 1 UNITE(s) N° de Lot: 1-45913-1	
23.0	AAC1633	N° D3140-92, Doubler	
Comment	Qty.: 1 UNITE(s)/Unit N° D3140-92, Doubler	Total : 1 UNITE(s) N° de Lot: 1-45913-14	
24.0	AAC1634	N° D3140-95, Doubler	
Comment	Qty.: 3 UNITE(s)/Unit N° D3140-95, Doubler	Total : 3 UNITE(s) N° de Lot: 1-45913-2	
25.0	AAC1636	N° D3140-98, Doubler	
Comment	Qty.: 1 UNITE(s)/Unit N° D3140-98, Doubler	Total : 1 UNITE(s) N° de Lot: 1-45913-17	
26.0	AAC1637	N° D3140-99, Doubler	
Comment	Qty.: 1 UNITE(s)/Unit N° D3140-99, Doubler	Total : 1 UNITE(s) N° de Lot: 1-45913-9	
27.0	AAC1638	N° D3140-101, Doubler	
Comment	Qty.: 2 UNITE(s)/Unit N° D3140-101, Doubler	Total : 2 UNITE(s) N° de Lot: 1-45913-10	
28.0	AAC1640	N° D3140-104, Doubler	
Comment	Qty.: 1 UNITE(s)/Unit N° D3140-104, Doubler	Total : 1 UNITE(s) N° de Lot: 1-45913-15	
29.0	AAC1642	N° D3140-106, Doubler	
Comment	Qty.: 1 UNITE(s)/Unit N° D3140-106, Doubler	Total : 1 UNITE(s) N° de Lot: 1-45913-16	
30.0	AAC1643	N° D3140-241, Doubler	
Comment	Qty.: 1 UNITE(s)/Unit N° D3140-241, Doubler	Total : 1 UNITE(s) N° de Lot: 1-45913-4	
31.0	AAC1645	N° D3140-303, Doubler	
Comment	Qty.: 2 UNITE(s)/Unit N° D3140-303, Doubler	Total : 2 UNITE(s) N° de Lot: 1-45913-6	
32.0	NETTOYAGE	Nettoyage des pièces	
			
Comment Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs			
Faire le nettoyage des doublers selon IG 0063.			
Quantité: 1 Date: 15/08/14 Lieu: 			

Date: Jeudi, 2014-05-08 14:25:01  
Utilisateur: marc dubé

## Feuille de Procédé

Client:	DART US DART AEROSPACE	Nom Dessin:	DOOR KIT
Numéro Job:	61668	Numéro	DKC135-0019/-0020
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
33.0	ASSEMBLAGE	Assemblage mécanique	
			
Comment	Setup: 960.0Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs		
	Mise en place des doublers et des pièces de la mousse structurale selon IF135-0002.		
Quantité:	1	Date:	19-08-14
Sceau:	 		
34.0	AAC1885	Tissu à délaminer Release ply B	
Comment	Qty.: 4.37 VERGE(s)/Unit Total : 4.37 VERGE(s)		
35.0	AAC1887	Wrighton 5200 Bleu P3	
Comment	Qty.: 7.18 VERGE(s)/Unit Total : 7.18 VERGE(s)		
36.0	AC0885	Feutre de drainage N° Airweave N 10	
Comment	Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s)		
37.0	AC0882	Sac à vide N° Strechlon 700	
Comment	Qty.: 7.770 VERGE(s)/Unit Total : 7.770 VERGE(s)		
38.0	AC0886	Ruban à gommer jaune #: T/AT-200Y	
Comment	Qty.: 2.0000 ROULEAU(s)/Unit Total : 2.0000 ROULEAU(s)		
39.0	BAGGING	Faire le bagging sur la pièce	
			
Comment	Setup: 0.00Hrs/ Run: 180.0000Min Total Run : 3.0000Hrs		
	Faire le montage cuisson selon IF135-0002 et IG 0012.		
Quantité:	1	Date:	19-08-14
Sceau:	 		
40.0	CUISSON	Cuisson de pièce	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs		
	Faire la cuisson de la pièce selon IF135-0002, IG 0012 et PTN #21. N° Cuisson: 2720		
Quantité:	1	Date:	19-08-14
Sceau:			
41.0	DÉMOULAGE	Démoulage de la pièce	
			
Comment	Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs		
	Retirer le montage cuisson de sur la pièce et enlever les résidus de ruban adhésif en teflon et les barres d'aluminium. Garder seulement la barre qui sépare les deux pièces.		
Quantité:	1	Date:	20/08/14
Sceau:	 		



Date: Jeudi, 2014-05-08 14:25:01

Utilisateur: marc dubé

## Feuille de Procédé

Client: DART US DART AEROSPACE

Nom Dessin: DOOR KIT

Numéro Job: 61668

Numéro DKC135-0019/-0020

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

42.0

DECOUPE

Découpe manuelle des pièces



Comment Setup: 0.00Hrs/ Run: 900.0000Min Total Run : 15.0000Hrs

Usinage des mousses structurales selon IF135-0002 et installer les doublers

Quantité: 1

Date: 25/08/14

Sceau: 73



43.0

INSPECTION

Inspection générale



Comment Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire la vérification de l'usinage intérieur pour s'assurer que tout soit conforme au dessin avant la prochaine étape.

Quantité: 1

Date: 25/08/14

Sceau: 73



Signature: [Signature]  
Date: 18/08/2014

44.0

AMB0211

Epoxy prepreg E-761 style 7781

Comment Qty.: 12.30 VERGE(s)/Unit Total: 12.30 VERGE(s)

Epoxy prepreg E-761 style 7781

N° de Lot:

ajoute à l'étape 5.0

18/08/2014

45.0

DRAPAGE

Drapage



Comment Setup: 0.00Hrs/ Run: 12.0000Hrs Total Run : 12.0000Hrs

Drapage de la coquille intérieure selon IF135-0002

+ plan de découpe et drapage

Quantité: 1

Date: 27-08-14

Sceau: 40



Signature: [Signature]  
Date: 18/08/2014

46.0

AAC1885

Tissu à délayer Release ply B

Comment Qty.: 4.37 VERGE(s)/Unit Total: 4.37 VERGE(s)

47.0

AAC1887

Wrightlon 5200 Bleu P3

Comment Qty.: 7.18 VERGE(s)/Unit Total: 7.18 VERGE(s)

48.0

AC0885

Feutre de drainage N° Airweave N 10

Comment Qty.: 6.00 VERGE(s)/Unit Total: 6.00 VERGE(s)

49.0

AC0882

Sac à vide N° Stretchlon 700

Comment Qty.: 7.770 VERGE(s)/Unit Total: 7.770 VERGE(s)

50.0















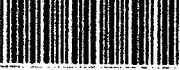






AC0886

Ruban à gommer jaune #: T/AT-200Y

Comment Qty.: 2.0000 ROULEAU(s)/Unit Total: 2.0000 ROULEAU(s)

Date: Jeudi, 2014-05-08 14:25:01  
Utilisateur: marc dubé






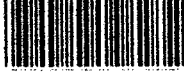



## Feuille de Procédé

Client: DART US DART AEROSPACE		Nom Dessin: DOOR KIT	
Numéro Job: 61668		Numéro DKC135-0019/-0020	
Numéro Job: 			
# Séq.:	Machine ou Opération:	Description :	
51.0	BAGGING	Faire le bagging sur la pièce	
 			
Comment Setup: 0.00Hrs/ Run: 180.0000Min Total Run : 3.0000Hrs			
Faire le montage cuisson selon IF135-0002 et IG 0012.			
Quantité: <u>1</u> Date: <u>27-08-14</u> Sceau:    			
52.0	CUISSON	Cuisson de pièce	
 			
Comment Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs			
Faire la cuisson de la pièce selon IF135-0002, IG 0012 et PTN #20. N°			
Cuisson: <u>8748</u>			
Quantité: <u>1</u> Date: <u>27-08-14</u> Sceau: 			
53.0	DÉMOULAGE	Démoulage de la pièce	
 			
Comment Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs			
Retirer le montage cuisson et faire des retouches sur la pièce afin d'enlever les surplus de résine et les résidus de tissus à délaminer.			
Retirer la pièce du moule.			
Quantité: <u>1</u> Date: <u>29/08/14</u> Sceau:  			
54.0	INSPECTION	Inspection générale	
 			
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Faire l'inspection par le département de la qualité "Tap test et inspection dimensionnelle".			
Quantité: <u>1</u> Date: <u>02/09/14</u> Sceau: 			
55.0	TRIMAGE	Trimage	
 			
Comment Setup: 0.00Hrs/ Run: 180.0000Min Total Run : 3.0000Hrs			
Faire le trimage de finition de la pièce selon IF135-0003.			
Quantité: <u>1</u> Date: <u>02-09-14</u> Sceau:  			

Date: Jeudi, 2014-05-08 14:25:01







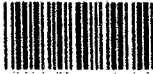
Utilisateur: marc.dubé

## Feuille de Procédé

<b>Client:</b> DART US DART AEROSPACE	<b>Nom Dessin:</b> DOOR KIT	
<b>Numéro Job:</b> 61668	<b>Numéro</b> DKC135-0019/0020	
Numéro Job: 		
<b># Séq.:</b>	<b>Machine ou Opération:</b>	<b>Description :</b>
56.0	AAC1021	Dupont Primer N° 7704S
<b>Comment</b> Qty.: 0.5000 UNITE(s)/Unit Total : 0.5000 UNITE(s) Dupont Primer N° 7704S N° de Lot: <u>474893041</u>		
57.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase
<b>Comment</b> Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s) N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: <u>[REDACTED]</u>		
58.0	PRIMER	Application primer
 		
<b>Comment</b> Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs  Faire l'application du primer selon IG 0008.  Quantité: <u>1</u> Date: <u>02-09-14</u> Sceau: <u>[Signature]</u> N° fiche Mélange: <u>6648</u>		
59.0	SABLAGE	Sablage
 		
<b>Comment</b> Setup: 0.00Hrs/ Run: 240.0000Min Total Run : 4.0000Hrs  Faire le sablage du primer selon IF135-0003.  Quantité: <u>1</u> Date: <u>03-09-14</u> Sceau: <u>[Stamp]</u>		
60.0	PRIMER	Application primer
 		
<b>Comment</b> Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs  Faire l'application du primer selon IG 0008.  Quantité: <u>1</u> Date: <u>04-09-14</u> Sceau: <u>[Signature]</u> N° fiche Mélange: <u>6633</u>  OK 5 sept 2014 IV		
61.0	IDENTIFICATION	Identification des pièces
 		
<b>Comment</b> Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs  Faire l'identification des pièces sur l'aluminium peinturé dans le dégagement des mécanismes de porte selon IG 0055.  N° de pièce Grosse porte: D3140-06 N° de pièce Petite porte: D3140-08 N° de Job ( sur les 2 pièces): <u>6668</u> Date de fabrication (sur les 2 pièces): <u>9-9-14</u> Sceau d'inspection.		


Date: Jeudi, 2014-05-08 14:25:01  
Utilisateur: marc dubé

## Feuille de Procédé

Client: DART US DART AEROSPACE		Nom Dessin: DOOR KIT	
Numéro Job: 61668		Numéro DKC135-0019/0020	
Numéro Job: 			
# Séq.:	Machine ou Opération:	9-9-14	44518m Description :
Quantité: <del>1</del> Date: <del>5-9-14</del> Sceau: 			
62.0	INSPEC FINAL	Inspection finale	
 			
Comment Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs			
Faire l'inspection finale des pièces par le département de la qualité selon le dessin D3140.			
Quantité: 1 Date: 09/09/14 Sceau: 			
63.0	EMBAL / ENTREPO	Emballage & Entreposage	
 			
Comment Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs			
Emballer et entreposer selon IG 0057.			
Quantité: 1 Date: 9-9-14 Sceau: 44518m			

N° Bon de travail: 61668

N° pièce: DOOR KIT  
DKC135-0019 / 0020

Article	Description	N° lot	Date de sortie	Heure de sortie	Temps restant Temp. Ambiante	Date expiration	Sceau employé
AAC1471	COPPER MESH						
AAC1541	CORE SPLICE						
AMB0211	EPOXY PREPREG	(R-1) 457570AA	25-06-14	14:30	720 H	23-12-14	
AMB0327	EPOXY PREPREG						
AMB0326	CARBONE						
AMB0442	FILM ADHÉSIF	1-45751-1	22-06-14	17:00	1440.	22-05-15	